

ASAP

RUSH.

Work Order ID 145036

145036

Page 1

Friday, April 29, 2016 3:30:01 PM

Item ID: D5420-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Doubler Plate

Start Date: 4/29/2016 Start Qty: 20.00

20

Cust Item ID:

Required Date: 5/6/2016 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: MF Date: 16-4-29 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5420	A								
100	FLOW WATER JET	0.06							
100									
Waterjet	Memo	0.40							
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: <u>A</u> Prog Rev: <u>A</u> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.20							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.40							
Quality Control									

DAS
38
9-89

MAY 03 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process	OTHER :							
Misidentified ☐	☐ Past Due								

Work Order ID 145036***145036***

Page 2

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 NC BRAKE Memo	0.00 0.00							<u>20 x 1</u> <u>16/05/00</u>
140 *140* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.40				<u>(20)</u>			DAS 38 9-89 MAY 04 2016
150 *150* SprayPaint Spray Painting	 Memo PRIME AS PER DWG 134188	0.00 0.00				<u>20</u>			DAS 41 9-89 6-5-4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Past Expiry Date ☐	☐ Manufacturing Process	OTHER :							
Misidentified ☐	☐ Past Due								

Work Order ID 145036

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Page 3

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Run Start ***NR1***

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

QC14- Inspect Spray Paint

0.00

160

QC

Memo

2.00

Quality Control

20DAS
38

9-89

MAY 05 2016

170

Identify as per dwg & Stock Location: 8/16/14

0.00

170

Packaging

Memo

0.00

Packaging

20x 8/16-05-6.

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

16/5/920160506

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Past Expiry Date ☐	☐ Manufacturing Process	OTHER :							
Misidentified ☐	☐ Past Due								

Picklist Print

Friday, April 29, 2016 3:30:00 PM

Page 1

Work Order ID: 145036

145036

Parent Item: D5420-1

D5420-1

Parent Item Name: Doubler Plate

Start Date: 4/29/2016

Required Date: 5/6/2016

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A 16.04.19 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.063

Purchased

No

sf

601.4830

2.526316

M6061T6S 063

2.8

Dec 16 / 05 / 03

6061-T6 .063 Sheet

Location

Loc Qty

Loc Code

MAT021

265.483

M132358

46.754

1.3

M133511

127.4

1.5

M134377

91.329

TPI

336

M134496

192

M134604

144

DQA: _____ Date: _____

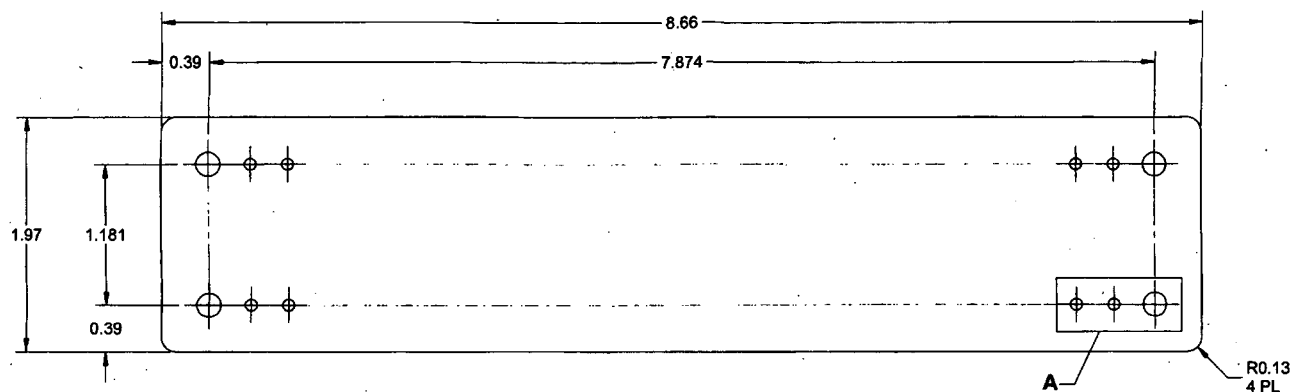


WORK ORDER NON-CONFORMANCE / UPDATE

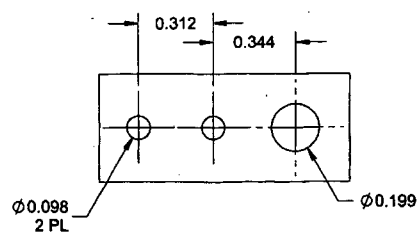
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Doc/Data ☐		Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
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Past Expiry Date ☐		Manufacturing Process ☐	OTHER :						
Misidentified ☐		Past Due ☐							



D5420-1 DOUBLER PLATE



DETAIL A
NUTPLATE HOLE PATTERN 4 PL
SCALE 2X

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: 0.10 lbs

RELEASED
2016-04-20
EN 16-564

APPROVED

A		NEW ISSUE		AJS	16.04.07
REV.	DESCRIPTION			BY	DATE
DESIGN	AJS	DART AEROSPACE LTD			
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA			
CHECKED	ML	DRAWING NO.	REV. A		
MFG. APPR.	DD	D5420	SHEET 1 OF 1		
APPROVED	WM	TITLE	SCALE		
DE APPR.	DS	DOUBLER PLATE	NT		
DATE	16.04.07	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR COMMERCIALITY TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.			

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WORK ORDER NON-CONFORMANCE / UPDATE

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